

Date: Monday, 03/11/2008 3:17:11 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	NUT PLATE ASSEMBLY
Job Number :	43176		
Estimate Number :	11053		
P.O. Number :		Part Number :	D2873043
This Issue :	03/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2873 REVA
First Issue :	/ /	Project Number :	N/A
Previous Run :	41988	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.11.03</u>	Due Date :	10/11/2008
Comment :	Est A05.09.13 New issue KJ/JLM	Qty:	20
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01000	6061T6 BAR .375 x 1.00
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Comment: Qty.: 0.3237 f(s)/Unit Total: 6.4743 f(s)

6061T6 BAR

Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B0.375x01.000)

Identify for D2873-3

Batch: 1716940

ml 08/11/04

(20)

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blanks: 1.000" x 0.375" x 3.700" long

ml 08/11/04

(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA and Dwg D2873

Identify as D2873-3 Dwg Rev A Folio Rev AA

H.A 08/11/04

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/11/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43176

Part Number: D2873043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 08/11/05

(20)

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

EP 08/11/05

(20)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/05

(20)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 08/11/11

(20X)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

EP 08/11/11

(20)

10.0 MS20426AD46 Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-6

Rivet

M105144

EP 08/11/11

11.0 MS21075L5 Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

M118136

EP 08/11/11

W/O:		WORK ORDER CHANGES					
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Date: Monday, 03/11/2008 3:17:11 PM
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Job Number:



Seq. #: Machine Or Operation: Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG #20

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-12

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43176
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	✓			
2.000	+/-0.010	2.001	✓			
0.750	+/-0.010	0.751	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	0.2502	✓			
1.000	+/-0.010	1.001	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	Ø0.131	✓			
0.359	+/-0.010	0.359	✓			
Ø0.316	+0.006/-0.001	Ø0.318	✓			
1.000	+/-0.010	1.005	✓			
0.250	+/-0.010	0.248	✓			
0.061	+/-0.010	0.059	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.231 x 0.124	✓			

Measured by: M.A	Audited by: [Signature]	Prototype Approval: N/A
Date: 08/11/04	Date: 08/11/05	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM [Signature]	[Signature]

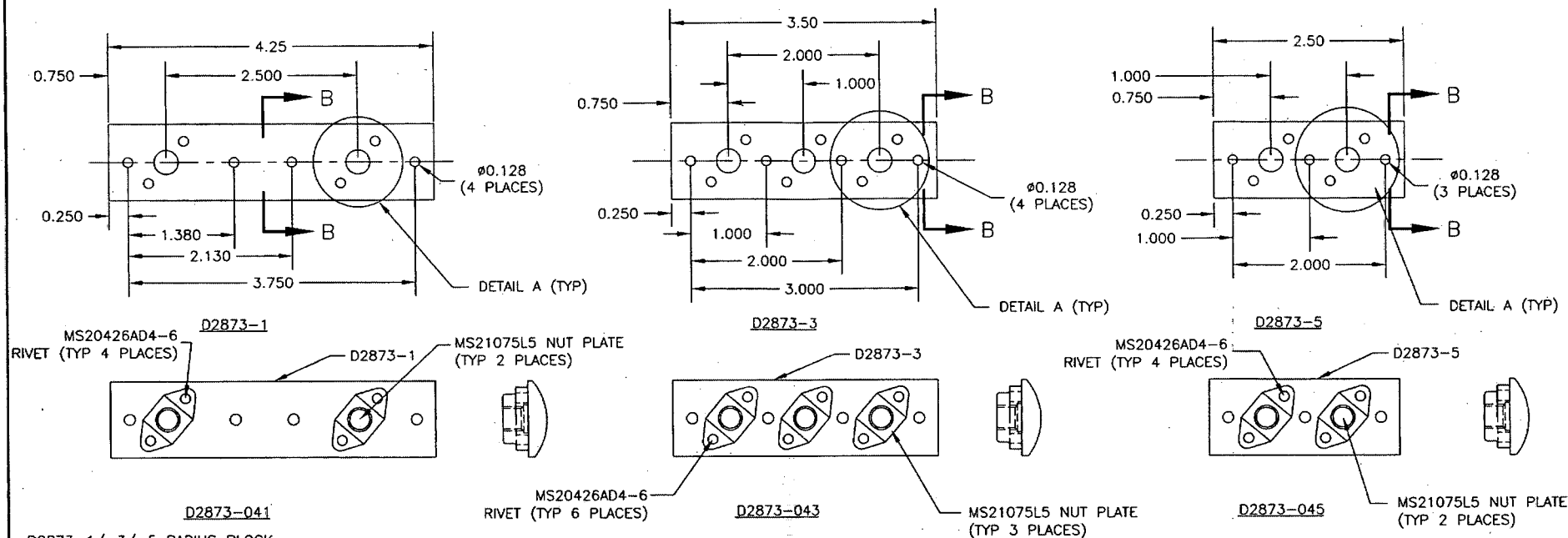
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D2873-1/-3/-5 RADIUS BLOCK

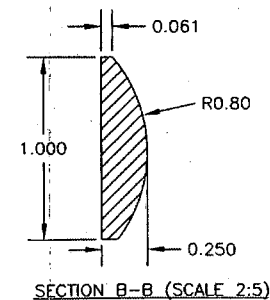
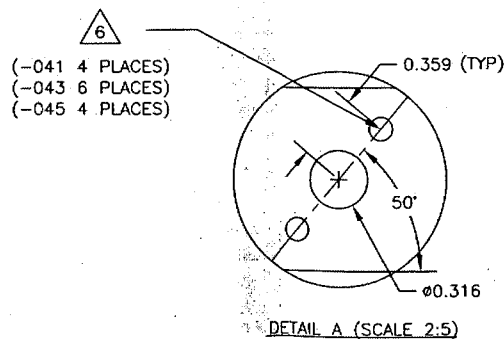
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED	PH	DART
APPROVED	PH	DART
DATE	05.07.26	05.07.26
TITLE	RADIUS BLOCK	REV. A
SCALE	4:5	SHEET 1 OF 1

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RELEASED
05.07.26

NO. 13324
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

W/O:		WORK ORDER CHANGES					
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